

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-50** Date Opened: **23-Mar-17** Title: **Fabrication**Aircraft OEM: **Multiple** Aircraft Model: **Multiple** Product Type: **Cargo Basket** Product Model: **Handle Bracket** Quantity: **140****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
84267	1	Handle Bracket	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

135
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
JC
JC
JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Cut stock sheet into strips
Machining - step 1 - Roughing
Cut rough parts into pieces
Machining - step 2 - Finishing
Machining - step 3 - Slot

Initial or N/A

DB
JC
JC
JC
JC

Work performed by:

ICC / Dual Inspection performed by:

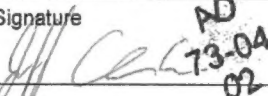
Work Order closed by:

Form 20.D.03

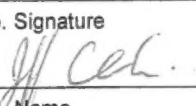
Print: J. ClarkePrint: J. RekvePrint: J. Clarke

Rev. Original 23 Sep 2014

Sign: Sign: Sign: SCA: AD02SCA: AD01SCA: AD02Date: 23-Jun-17Date: 23-Jun-17Date: 26-Jun-17

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0058
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice PO 11170
6. Item 1.	7. Description Handle Bracket	8. Part Number 84267-01	9. Qty. 3	10. Serial/Batch No. WO 2017-50	11. Status/Work New
12. Remarks Certification data: TCCA STC SH00-48					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 27 Mar 2018		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

BLACKCOMP HELICOPTERS

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0059		
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice N/A		
6. Item 1.	7. Description Handle Bracket	8. Part Number 84267-01	9. Qty. 2	10. Serial/Batch No. WO 2017-50	11. Status/Work New		
12. Remarks Certification data: TCCA STC SH00-48							
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.				
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 27 Mar 2018		14d. Name		14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>							

White Saddle



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Unserviceable

Remarks

PARTS DESTROYED 23 JUNE 2017 JK.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: HANDLE BRACKET QTY 2 PC 3

Manufacturer: AERO DESIGN LTD.

Part No.: 84267-01 Serial / Batch No.: P0 1796

TTSN: N/A TSO: N/A Rem.: N/A

Removed From: N/A

Reason For Removal: UNDER HEIGHT @ OUTER POINT

A/C Hours at Removal: N/A WO.# 2017-50

Signature: [Signature]

Date: 23 JUNE 2017 Lic. No. / SCA AD02

Unserviceable



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: HANDGE BRACKET No. of pieces: 140

Manufacturer: AERO DESIGN LTD.

Part No.: 84267-01 Serial/Batch No.: PO 17016

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-50

Remaining Tasks to be Performed: CUT STOCK STRIPS, 1ST MACHINING ✓
CUT APART, 2ND MACHINING, SLOT, DEBURR, INSPECT ✓

Signature: [Signature]

Date: 27 MAR 2017 Lic. No. / SCA AD02

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

-5 UNDER TOLERANCE, RED TAGS ISSUED 23 JUN 2017 JC.

Complete, Green tag issued 24 May 2017 JC.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0288
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice 2017-50
6. Item 1.	7. Description Handle Bracket	8. Part Number 84267-01	9. Qty. 1	10. Serial/Batch No. NSN	11. Status/Work New
12. Remarks None.					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 01 Aug 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

LAKESE AIR



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: HANDKE BRACKET QTY 2

Manufacturer: AERO DESIGN LTD.

Part No.: 84267-01 Serial / Batch No.: PD17016

TTSN: N/A TSO: N/A Rem.: N/A

Removed From: N/A

Reason For Removal: CHIP ON OUTER EDGE

A/C Hours at Removal: N/A WO.# 2017-50

Signature: [Signature]

Date: 23 JUNE 2017 Lic. No. / SCA A202

Unserviceable



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

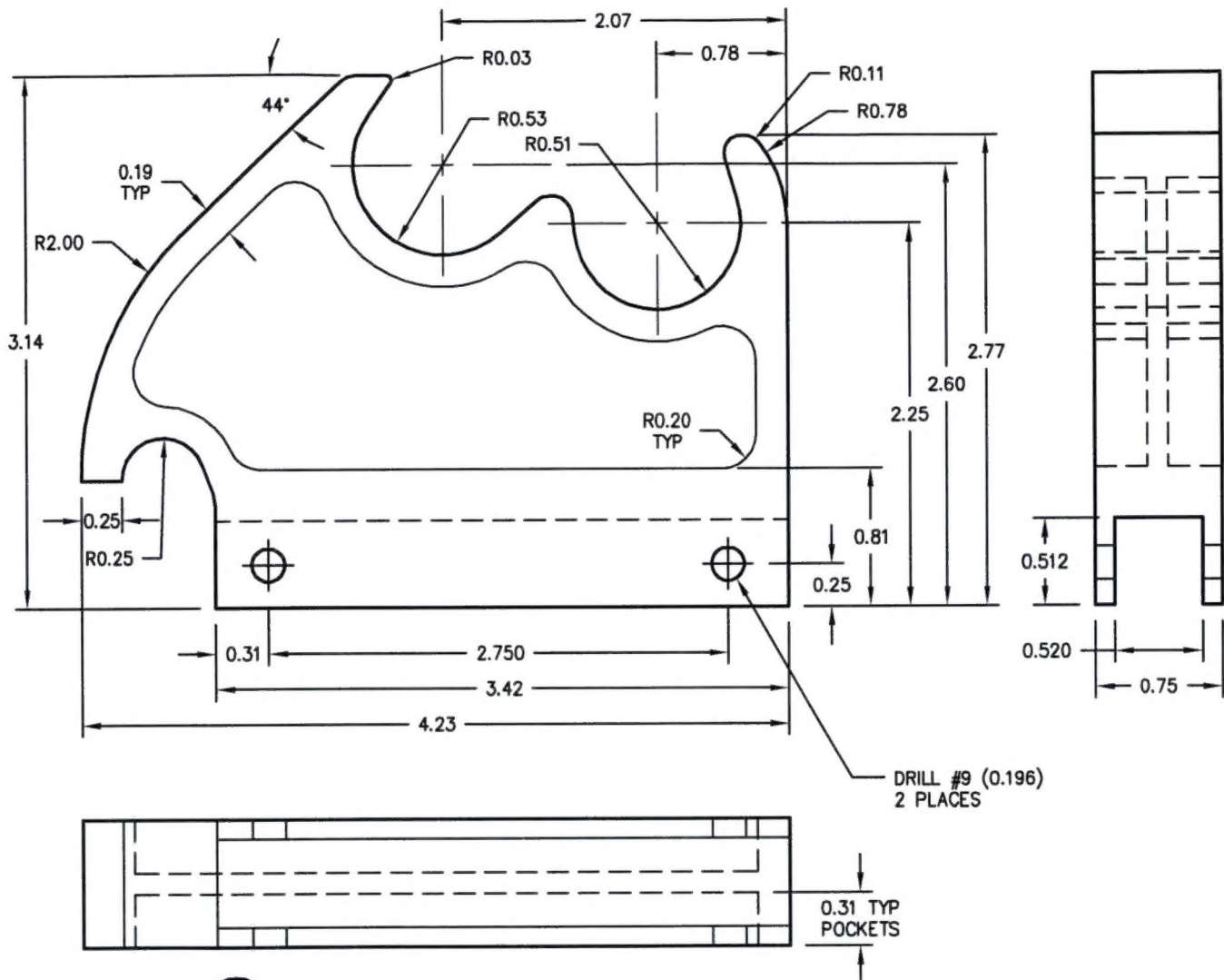
AMF 73-04

Unserviceable

Remarks

PARTS DESTROYED 23 JUN 2017 JC.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED	BJC	MAR 13/14




01 HANDLE BRACKET

PART TO BE CNC MACHINED USING DRAWING AS A TEMPLATE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

84267-01	01	HANDLE BRACKET	ACETAL PLASTIC	COMMERCIAL	0.75 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS					
QTY					

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS		DATE		 <div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca</div>
	DRAWN: R. RATHWELL		JUNE 18/09		
	CHECKED: E. BURGOIN				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				HELICOPTER CARGO BASKET HANDLE BRACKET
	SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1		A4	84267	1	

COMPONENT – HANDLE BRACKET

General

These instructions apply to all cargo basket handle brackets. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84267, Rev. 2

QTY 140

Work Order: 2017-50

Date Open: 23 MAR 2017

Complete
(initial or SCA #)

AD
73-04
01

1. Prepare Stock

- a. Stock 0.75" Delrin (black acetal plastic) sheet, typically 2' x 4'.

Stock PO # 17016

- b. Rip stock strips 4.5" wide x 24" long (across sheet) on table saw. Ensure straight cuts.
c. Deburr edges.
d. Yellow tag stock strips and place on in progress shelf in machine shop.

AD
73-04
02

2. CNC Machining

- a. Ensure CNC mill enclosure is completely clean and dry.
b. Locate stock strip in vises on CNC mill with 22" long jaws. Set 0 locations using aluminum bar.
c. Connect air line to automatic coolant nozzle.
d. Run CNC program for roughing and first side (O84201 and O84202). Repeat for all stock strips.
e. Update yellow tag and place rough machined strips in fabrication shop for cutting.

AD
73-04
01

3. Cut Rough Stock

- a. Cut rough parts from strips along marked lines on strips.
b. Cut upper left corner from left bracket on end of strip, use another bracket as a guide.
c. Update yellow tag and place rough cut brackets on in progress shelf in machine shop.

AD
73-04
02

4. CNC Machining

- a. Load jig for holding rough cut brackets in vises on CNC mill.
b. Run CNC program for finishing and second side (O84205 and O84299).
c. Load vise jaws for holding bracket for back slot
d. Run CNC program for inboard slot (O84206).
e. Deburr finished parts.

AD
73-04
01

5. Final Inspection

To be completed by a different person than the previous steps.

- a. Green tag complete and inspected parts in preparation for installation.